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011022

D2332-041

Job Sheet 193524



Part No: D2332-041

Job Qty: 10 pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                  | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off                         |
|-------|----------------------------|--------|------------|----------|-----------|---------|-----------------------------|-----------|----------------------------------|
|       |                            |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |                                  |
| 100   | Small Fab - 1              | 10 pcs | 5/3/19     |          | 0.32      | 3.13    | Small Fab - 1               |           | SMB<br>19/7/15                   |
|       |                            |        |            |          |           |         | Small Fab - 2               |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 3               |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 4               |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 5               |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 6               |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 7               |           |                                  |
| 110   | Small Fab - Brake NC - B4B | 10 pcs | 5/3/19     |          | 0.00      | 1.14    | Small Fab - Brake - 1 - B4B |           | SMB 19/7/16                      |
|       |                            |        |            |          |           |         | Small Fab - Brake - 2 - B4B |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - Brake - 3 - B4B |           |                                  |
| 120   | Small Fab - 2 - B4B        | 10 pcs | 5/3/19     |          | 0.00      | 3.13    | Small Fab - 1 - B4B         |           | SMB<br>19/7/17                   |
|       |                            |        |            |          |           |         | Small Fab - 2 - B4B         |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 3 - B4B         |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 4 - B4B         |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 5 - B4B         |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 6 - B4B         |           |                                  |
|       |                            |        |            |          |           |         | Small Fab - 7 - B4B         |           |                                  |
| 130   | QC 5                       | 10 pcs | 5/3/19     |          | 0.00      | 0.00    | QC 5 - 10                   |           | DAS<br>24<br>9-89<br>JUL 22 2019 |
|       |                            |        |            |          |           |         | QC 5 - 12                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 17                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 18                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 19                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 22                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 24                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 3                    |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 43                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 49                   |           |                                  |
|       |                            |        |            |          |           |         | QC 5 - 51                   |           |                                  |

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|     |                               |        |        |           |                      |                    |
|-----|-------------------------------|--------|--------|-----------|----------------------|--------------------|
|     |                               |        |        |           | QC 5 - 58            |                    |
|     |                               |        |        |           | QC 5 - 68            |                    |
|     |                               |        |        |           | QC 5 - 9             |                    |
|     |                               |        |        |           | QC 5 - 50            | <i>EL</i>          |
|     |                               |        |        |           | QC 5 - 30            |                    |
|     |                               |        |        |           | QC 5 - 40            |                    |
| 140 | Large Fab - Welded Assy-2-B4B | 10 pcs | 5/3/19 | 0.00 2.49 | Large Fab - 1 - B4B  | <i>EL</i>          |
|     |                               |        |        |           | Large Fab - 10 - B4B |                    |
|     |                               |        |        |           | Large Fab - 2 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 3 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 4 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 5 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 6 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 7 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 8 - B4B  |                    |
|     |                               |        |        |           | Large Fab - 9 - B4B  |                    |
| 150 | QC 9                          | 10 pcs | 5/3/19 | 0.00 0.00 | QC 9 - 10            |                    |
|     |                               |        |        |           | QC 9 - 18            |                    |
|     |                               |        |        |           | QC 9 - 24            | <b>DAS 24 9-89</b> |
|     |                               |        |        |           | QC 9 - 43            | <b>JUL 22 2019</b> |
|     |                               |        |        |           | QC 9 - 50            |                    |
|     |                               |        |        |           | QC 9 - 9             |                    |
| 160 | QC 5                          | 10 pcs | 5/3/19 | 0.00 0.00 | QC 5 - 10            |                    |
|     |                               |        |        |           | QC 5 - 12            |                    |
|     |                               |        |        |           | QC 5 - 17            |                    |
|     |                               |        |        |           | QC 5 - 18            |                    |
|     |                               |        |        |           | QC 5 - 19            |                    |
|     |                               |        |        |           | QC 5 - 22            | <b>DAS 24 9-89</b> |
|     |                               |        |        |           | QC 5 - 24            | <b>JUL 22 2019</b> |
|     |                               |        |        |           | QC 5 - 3             |                    |
|     |                               |        |        |           | QC 5 - 43            |                    |
|     |                               |        |        |           | QC 5 - 49            |                    |
|     |                               |        |        |           | QC 5 - 51            |                    |
|     |                               |        |        |           | QC 5 - 58            |                    |
|     |                               |        |        |           | QC 5 - 68            |                    |
|     |                               |        |        |           | QC 5 - 9             |                    |
|     |                               |        |        |           | QC 5 - 50            |                    |
|     |                               |        |        |           | QC 5 - 30            |                    |
|     |                               |        |        |           | QC 5 - 40            |                    |
| 170 | Small Fab - 3 - B4B           | 10 pcs | 5/3/19 | 0.00 3.13 | Small Fab - 1 - B4B  | <i>Smb</i>         |
|     |                               |        |        |           | Small Fab - 2 - B4B  |                    |
|     |                               |        |        |           | Small Fab - 3 - B4B  | <i>219/07/23</i>   |
|     |                               |        |        |           | Small Fab - 4 - B4B  |                    |
|     |                               |        |        |           | Small Fab - 5 - B4B  |                    |
|     |                               |        |        |           | Small Fab - 6 - B4B  |                    |
|     |                               |        |        |           | Small Fab - 7 - B4B  |                    |
| 180 | QC 5                          | 10 pcs | 5/3/19 | 0.00 0.00 | QC 5 - 10            |                    |
|     |                               |        |        |           | QC 5 - 12            |                    |
|     |                               |        |        |           | QC 5 - 17            |                    |
|     |                               |        |        |           | QC 5 - 18            |                    |
|     |                               |        |        |           | QC 5 - 19            |                    |
|     |                               |        |        |           | QC 5 - 22            |                    |
|     |                               |        |        |           | QC 5 - 24            |                    |
|     |                               |        |        |           | QC 5 - 3             |                    |
|     |                               |        |        |           | QC 5 - 43            |                    |
|     |                               |        |        |           | QC 5 - 49            | <b>DAS 81 9-89</b> |
|     |                               |        |        |           | QC 5 - 51            | <b>JUL 23 2019</b> |
|     |                               |        |        |           | QC 5 - 58            |                    |
|     |                               |        |        |           | QC 5 - 68            |                    |



|     |                             |           |        |           |                                 |
|-----|-----------------------------|-----------|--------|-----------|---------------------------------|
|     |                             |           |        | QC 5 - 9  |                                 |
|     |                             |           |        | QC 5 - 50 |                                 |
|     |                             |           |        | QC 5 - 30 |                                 |
|     |                             |           |        | QC 5 - 40 |                                 |
| 190 | Packaging 3-1 - Stock - B4B | 10<br>pcs | 5/3/19 | 0.00 0.00 | Packaging 3 - 1 - B4B           |
|     |                             |           |        |           | Packaging 3 - 2 - B4B           |
|     |                             |           |        |           | Packaging 3 - 3 - B4B <i>02</i> |
|     |                             |           |        |           | Packaging 3 - 4 - B4B           |
|     |                             |           |        |           | Packaging 3 - 5 - B4B           |
|     |                             |           |        |           | Packaging 3 - 6 - B4B           |
|     |                             |           |        |           | Packaging 3 - 7 - B4B           |
|     |                             |           |        |           | Packaging 3 - 8 - B4B           |
|     |                             |           |        |           | Packaging 3 - 9 - B4B           |
|     |                             |           |        |           | Packaging 3 - 10 - B4B          |
|     |                             |           |        |           | Packaging 3 - 11 - B4B          |
|     |                             |           |        |           | Packaging 3 - 12 - B4B          |
|     |                             |           |        |           | Packaging 3 - 13 - B4B          |
|     |                             |           |        |           | Packaging 3 - 14 - B4B          |
|     |                             |           |        |           | Packaging 3 - 15 - B4B          |
|     |                             |           |        |           | Packaging 3 - 16 - B4B          |
|     |                             |           |        |           | Packaging 3 - 17 - B4B          |
|     |                             |           |        |           | Packaging 3 - 18 - B4B          |
|     |                             |           |        |           | Packaging 3 - 19 - B4B          |
|     |                             |           |        |           | Packaging 3 - 20 - B4B          |
|     |                             |           |        |           | Packaging 3 - 21 - B4B          |
|     |                             |           |        |           | Packaging 3 - 22 - B4B          |
|     |                             |           |        |           | Packaging 3 - 23 - B4B          |
|     |                             |           |        |           | Packaging 3 - 24 - B4B          |
|     |                             |           |        |           | Packaging 3 - 25 - B4B          |
|     |                             |           |        |           | Packaging 3 - 26 - B4B          |
|     |                             |           |        |           | Packaging 3 - 27 - B4B          |
|     |                             |           |        |           | Packaging 3 - 28 - B4B          |
|     |                             |           |        |           | Packaging 3 - 29 - B4B          |
|     |                             |           |        |           | Packaging 3 - 30 - B4B          |
|     |                             |           |        |           | Packaging 3 - 31 - B4B          |
|     |                             |           |        |           | Packaging 3 - 32 - B4B          |
|     |                             |           |        |           | Packaging 3 - 33 - B4B          |
|     |                             |           |        |           | Packaging 3 - 34 - B4B          |
|     |                             |           |        |           | Packaging 3 - 35 - B4B          |
|     |                             |           |        |           | Packaging 3 - 36 - B4B          |
| 200 | QC 21 - SA                  | 10<br>pcs | 5/3/19 | 0.00 0.00 | QC 21 - SA - 21                 |
|     |                             |           |        |           | QC 21 - SA - 70                 |
|     |                             |           |        |           | QC 21 - SA - 53                 |

Bin: FP001

DAG

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1-35

JUL 23 2019

Part Op **100** - (Small Fab) 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing  
 Descriptions: 7.735" long. 3- Deburr.  
**110** - (Punch ends and deburr as per dwg) Punch and form D2332-11 to length as per dwg D2332 using DT8012 ( need 2 per ass'y)  
**120** - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube  
**130** - (QC5- Inspect part completeness to step on W/O)  
**140** - (Weld per dwg A/R S.S. rod Batch: \_\_\_\_\_) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)  
 \*\*\*\*\*ensure nothing is inside of tube before welding\*\*\*\*\* S.S Rod batch: \_\_\_\_\_  
**150** - (QC9- Inspect visual per QSI004- Fusion Welds)  
**160** - (QC5- Inspect part completeness to step on W/O)  
**170** - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332  
**180** - (QC5- Inspect part completeness to step on W/O)  
**190** - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
**200** - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item      | Component Name              | Quantity             | Operation                      | Container    |
|------------------|-----------------------------|----------------------|--------------------------------|--------------|
| M304R0.250       | 304 SS Round bar .250       | 1 ft (.1 ea)         | 100-Small Fab - 1              | 5175073      |
| M304TR1.000W.049 | 304 Round Tube 1.00 X .049W | 4.3000 ft (.43 ea)   | 100-Small Fab - 1              | 5135662      |
| M304TR0.500W.035 | 304 Round Tube .500 X .035W | 12.5000 ft (1.25 ea) | 110-Small Fab - Brake NC - B4B | 5173386      |
| AN4-4A           | Bolt                        | 10 Ea (1 ea)         | 170-Small Fab - 3 - B4B        | 5148662      |
| MS21042L4        | Nut                         | 10 Ea (1 ea)         | 170-Small Fab - 3 - B4B        | 5179638      |
| NAS1149D0416J    | Washer                      | 30 Ea (3 ea)         | 170-Small Fab - 3 - B4B        | 51 f m 13511 |

## Job Allocations

| Operation                      | Component Part   | Required | Inventory | Allocated |
|--------------------------------|------------------|----------|-----------|-----------|
| 100-Small Fab - 1              | M304R0.250       | 1        | 12        | 0         |
|                                | M304TR1.000W.049 | 4        | 11        | 0         |
| 110-Small Fab - Brake NC - B4B | M304TR0.500W.035 | 13       | 145       | 0         |
| 170-Small Fab - 3 - B4B        | AN4-4A           | 10       | 74        | 0         |
|                                | MS21042L4        | 10       | 2,004     | 0         |
|                                | NAS1149D0416J    | 30       | 1,859     | 0         |

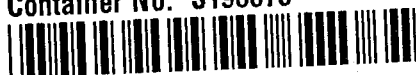
## Part Specifications

| Spec No | Description       | Target/Tolerance    | Limits         | Type | Special Comments |
|---------|-------------------|---------------------|----------------|------|------------------|
| 1       | Lid Prop Assembly | 5.000Inches ± 0.030 | 5.030<br>4.970 |      |                  |
| 2       | Lid Prop Assembly | 1.250Inches ± 0.010 | 1.260<br>1.240 |      |                  |
| 3       | Lid Prop Assembly | 6.690Inches ± 0.010 | 6.700<br>6.680 |      |                  |

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Container No: S198373



Part: D2332-041

Job No: 193524

Serial No/Batch: S198373

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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